

Date: Thursday, 11/12/2008 10:15:39 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEARSHOE
Job Number :	44007		
Estimate Number :	12788		
P.O. Number :		Part Number :	D356413
This Issue :	11/12/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3564 REVD
First Issue :	1/1/08	Project Number :	N/A
Previous Run :	42257	Drawing Revision :	D
		Material :	
		Due Date :	19/12/2008
Written By :		Qty:	12
		Um:	Each
Checked & Approved By :	<u>JLD 08.12.11</u>		
Comment :	Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 0.2331 sf(s)/Unit Total: 2.7972 sf(s)
 M304S16GA Stainless steel sheet 0.063" thick
 Batch: 109057 B 8-12-12

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3564
 Dwg Rev: D
 Prog Rev: D

B 8-12-12

2-Deburr if necessary B 8-12-12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-12-12**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK08-12-12

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

Deburr if necessary
 Form on Brake as per Dwg D3564 using Jigs DT .8179 and DT 8155

B 09/01/08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/12/2008 10:15:39 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 44007

Part Number: D356413

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

S 09/01/13 (12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

6:40

OVEN TEMPERATURE:

320°

FINISH TIME:

7:10

FZ 09/01/13 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-13

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-16

HL

09-01-13

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/14 (12)

Job Completion



MF 09-1-13

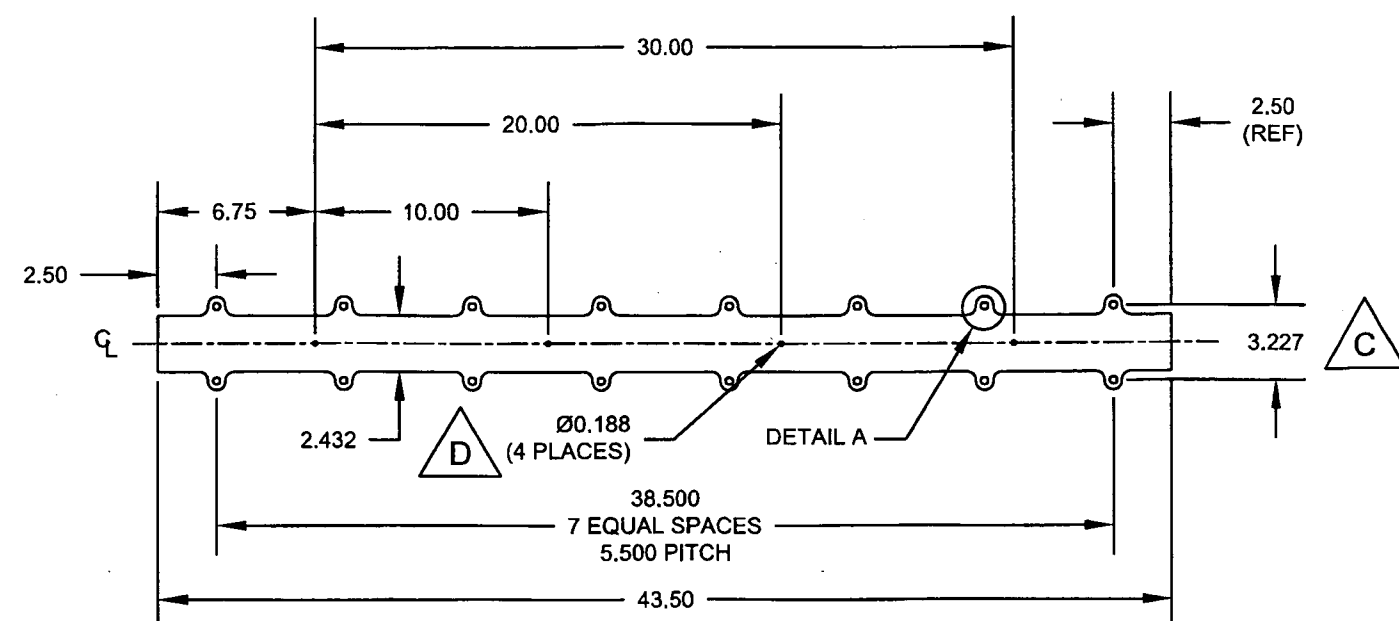
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

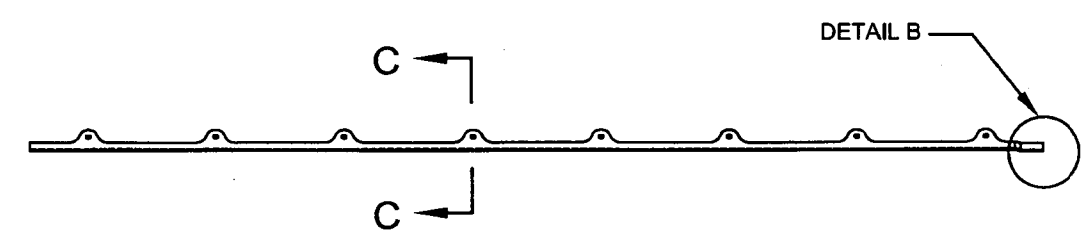
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

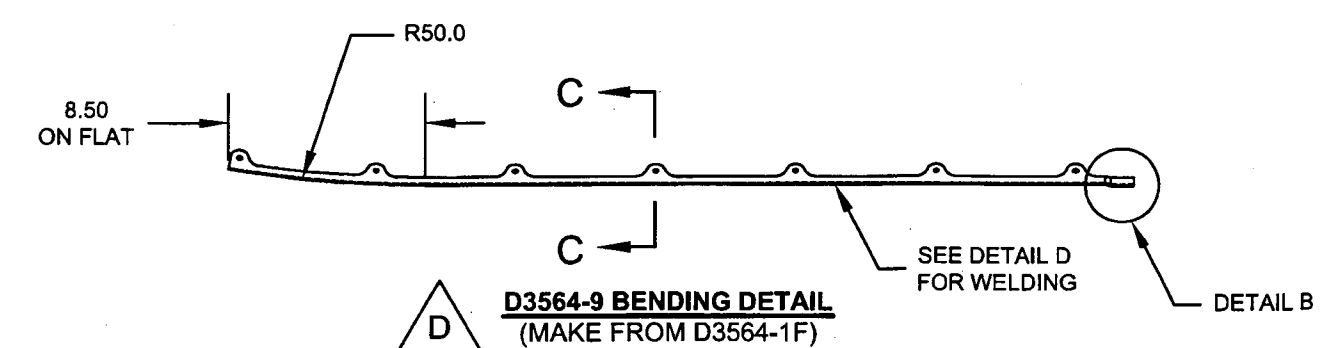
NOTE: Date & initial all entries



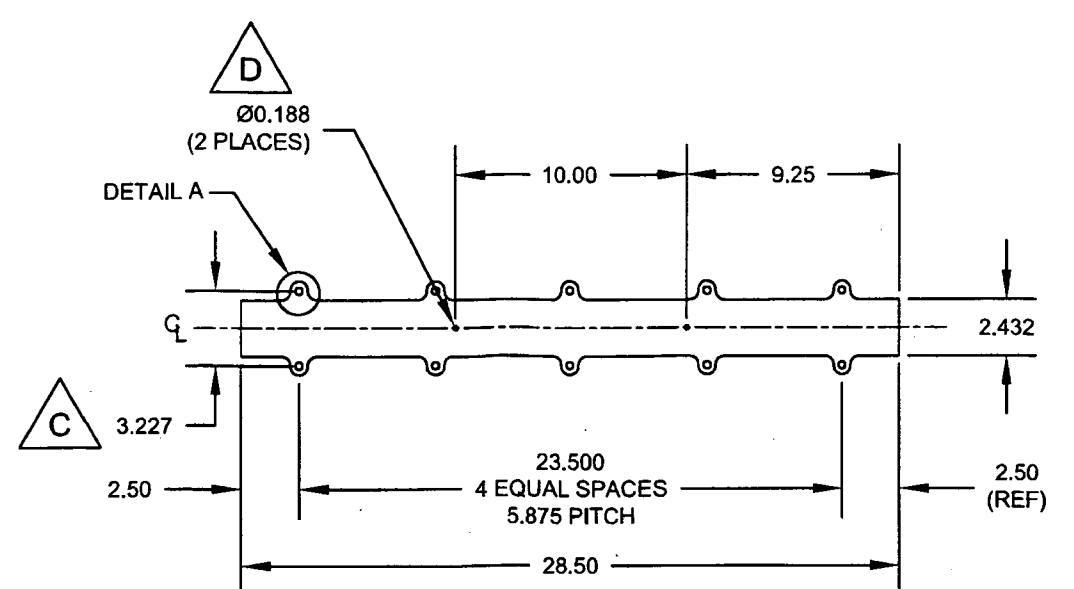
D3564-5F FLAT PATTERN



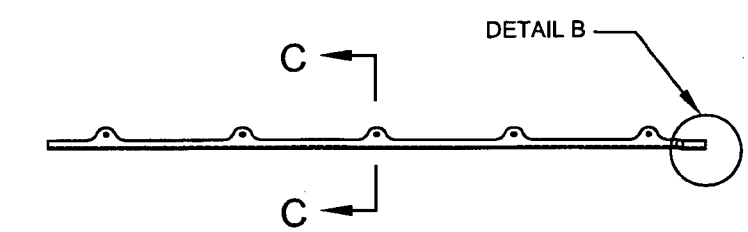
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



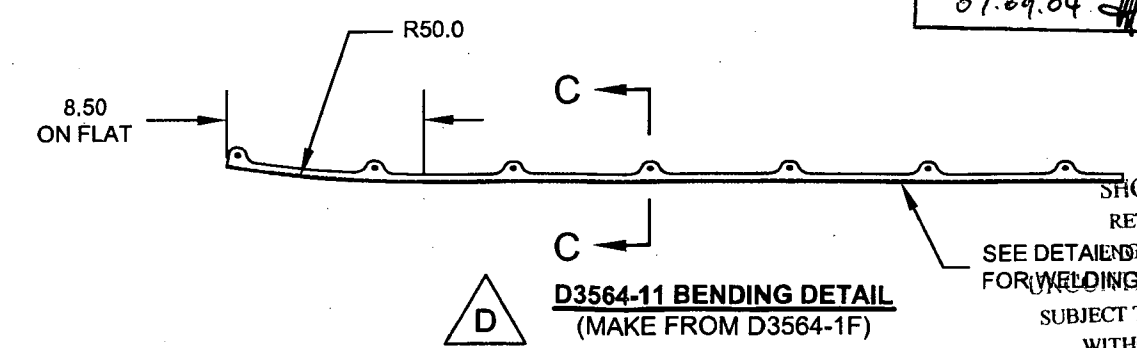
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)

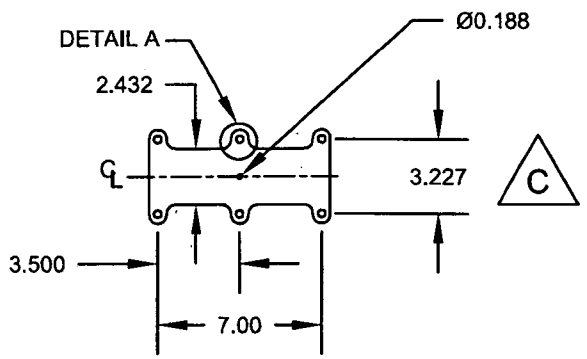


D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

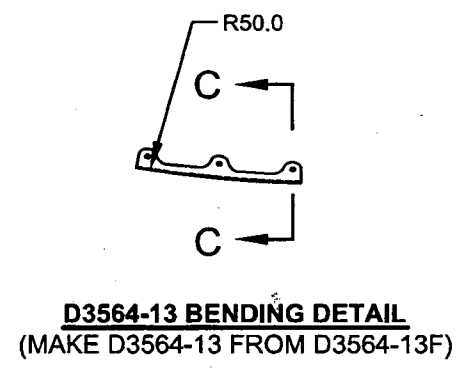
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WORK ORDER
NO. 44007

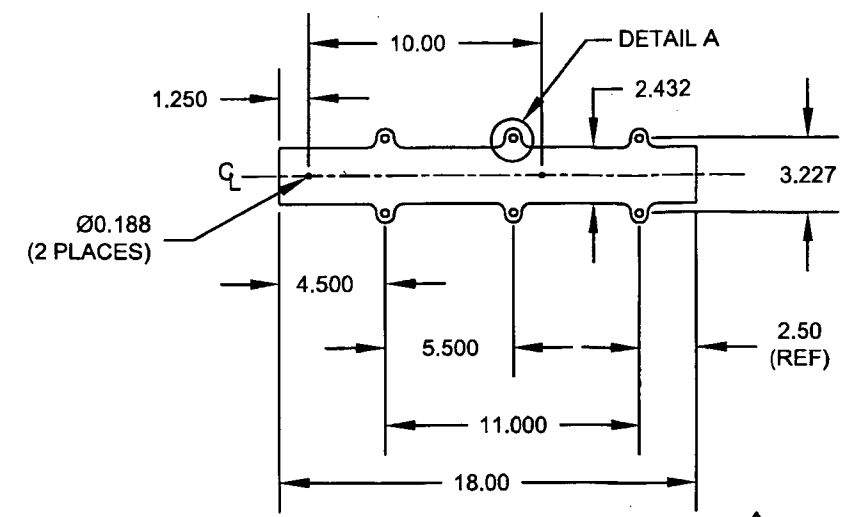
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MFG. APPR.	PH	D3564	SHEET 2 OF 3
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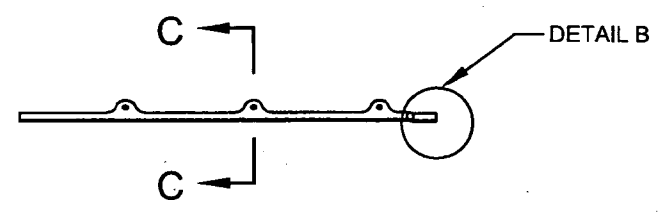
D3564-13F FLAT PATTERN



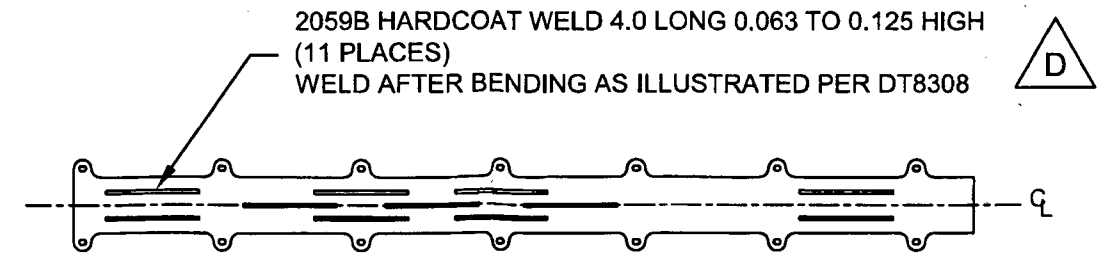
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



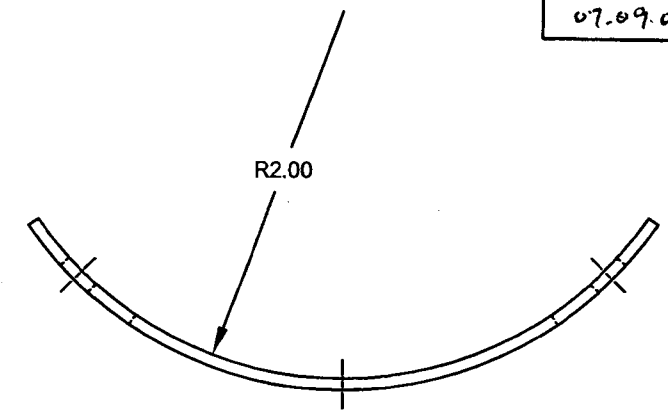
D3564-15F FLAT PATTERN



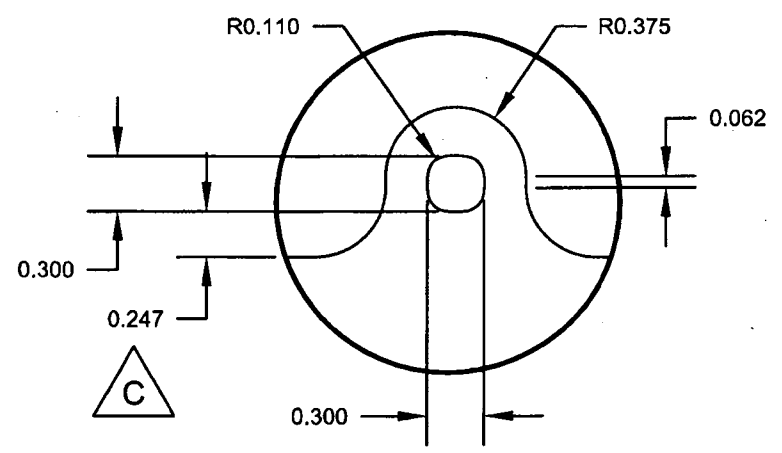
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



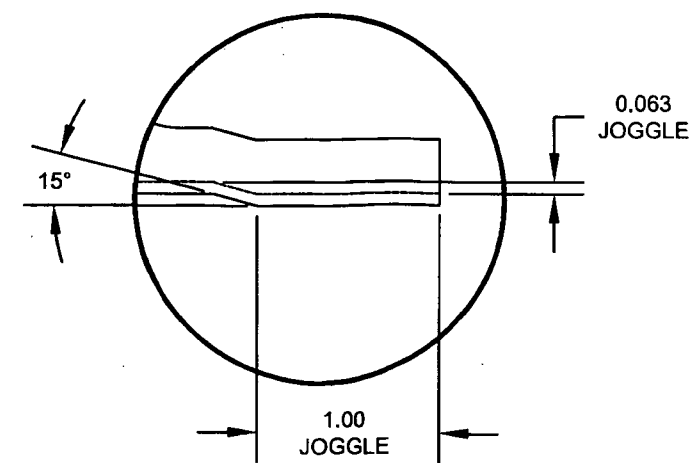
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

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DE APPR.	PH	WEARSHOE	1:8
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